

5818

Dart Aerospace Ltd.

Date: Thursday, 24/07/2008 8:21:26 AM
User: Melanie Fauteux

Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number : 40607	
Estimate Number : 13436	
P.O. Number :	Part Number : PB674300113
This Issue : 24/07/2008 S.O. No. :	Drawing Number : PB6743001 P.8
Prsht Rev. : NC	Project Number : N/A
First Issue : 17/07/2008 Type : LARGE FAB ASSY	Drawing Revision : B1
Previous Run :	Material :
Written By :	Due Date : 24/07/2008
Checked & Approved By : MF 08-07-24	Qty: Um: Each
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001255	Inner Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 40541		



MF 08-07-22

2.0	PB6743001249	Inner Tube Bushing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: mi8141		



MF 08-07-22

3.0	PB6743001253	Gusset
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340711		



MF 08-07-22

4.0	PB6743001254	Gusset
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340053		



MF 08-07-22

5.0	PB674300167	PB67-43001-67
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-67 batch: 340243		



MF 08-07-22

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Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

08-07-28 5

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-07-29 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/29 (5)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT

M 17935

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

08-07-31

(5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/31 (5)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-07-31

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

08/07/31

(SX)

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Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320
2:10

M-1

08/07/31

(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/31

(5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

90 Degree Cover Plate

batch: 240069

was done for only 2 up to 12

08-08-26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

see attached

08-08-26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: M102926

08-08-26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: M108473

08-08-26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

08-08-26

3

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Part Number: PB4300113

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23



21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Carl welan

S 08/10/23



22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion





